

Work Order ID 51506

August 25, 2009 1:34:05 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 8/24/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/24/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Blmf

Date: *09-8-25*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A *[Signature]*

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend I

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

> DP 9-9-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

SAP 09-10-02

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 502/10/02



f

W/O:		WORK ORDER CHANGES					
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Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R L R Aluminum Rod

mill 999

BE 09/10/08

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R L R Aluminum Rod

mill 999

BE 09/10/08

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

AWM 9-10-13

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	27 S 08/10/13			(X)	/		
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	27 S 08/10/13			(X)	/		
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00	27 S 08/10/14			(X)	/		

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:00A~
OVEN TEMPERATURE: 320F~
FINISH TIME: 10:30A~

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



=> ell 109/10/11

(Y) 8

BR 09-10-14

10

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R [1111] Sikaflex-291 [1111] M112391
Sikaflex expire date: 10/20

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R [1111] Sikaflex-291 [1111] M112391
Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: M11210p

mp 09/10/14

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00

⇒ 8/24/09

QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev:

PPP 51994

230

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

PC 9/14/22 (1)

09/10/23

MF
09-10-23

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Picklist Print

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Page 1
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Work Order ID: 51506

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Start Date: 8/24/09

Required Date: 8/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2580-1RevD

Manufactured

No

110

Each

14.0000

1.0000



205 Skidtube bent detail

B51752
D9-9-29

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

LG

13

50757

3

50761

6

50976

2

50977

2

Main Warehouse

ST

1

50758

1

D2576-3RevG

Manufactured

No

140

Each

141.0000

1.0000



Step (maching detail)

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

141

43504

40

46661

101

1 BE 09/10/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			140	Each	464.0000	20.0000			



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

464

43988

4

46434

4

46956

2

47797

9

48272

22

51314

100

51315

323

B 51525 x 20

BE 09-10-06

D2855RevA

Manufactured No

200

Each

29.0000

1.0000



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

-1

50513

-1

Main Warehouse

FP6

31

50513

31

Main Warehouse

ST

-1

50513

-1

50770

XL mo 09/10/14

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Shop Packet Print

Page 2

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A		Purchased	No			200	Each	2,515.000	2.0000			
												
Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2515

100188

212

105057

2245

15205

58

AN960JD10L

Purchased

No

200

Each

6,679.000

2.0000



Washer



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

-2

109632

-2

Main Warehouse

ST

6681

101291

16

104885

153

105793

236

109632

1276

110985

5000

XZ MD 09/10/14

XZ MD 09/10/14

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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ALS7-1032-130		Purchased	No			200	Each	3,628.000	50.0000			



Insert

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse	112772	
ST	3628	
105855	16	
108606	52	
111529	1560	
111779	2000	

XSO MD 09/10/14

AN3C4A Purchased No

200 Each 632.0000 50.0000



BOLT

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse	112724	
FP	-50	
112314	-50	
Main Warehouse		
ST	682	
112082	30	
112314	652	

XSO MD 09/10/14

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L		Purchased	No			200	Each	2,946.000	50.0000			



washer

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

FP

-50

112116

-50

Main Warehouse

ST

2896

112116

2896

D3566-13RevC

Manufactured

No

200

Each

20.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

-1

48166

-1

Main Warehouse

ST

21

45717

1

46889

1

48166

3

50265

16

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D3566-5RevC		Manufactured	No			200	Each	17.0000	1.0000			
												
Gasket												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

-1

51260

-1

Main Warehouse

ST

18

36113

1

46186

1

47318

1

48167

1

51260

14

XL mp 09/10/14

D3566-1RevC

Manufactured

No

200

Each

27.0000

2.0000



Gasket



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

-2

51259

-2

Main Warehouse

ST

29

46349

1

47434

2

51218

1

51259

25

X2 md 09/10/14

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D3564-11RevD		Manufactured	No			200	Each	29.0000	1.0000			



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	22	
51256	22	
Main Warehouse		
FP19	-1	
50112	-1	
Main Warehouse		
ST	8	
45823	1	
50112	7	

51506

21 MD @ 9/10/14

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:04 PM

Work Order ID: 51506

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-13RevD		Manufactured	No			200	Each	30.0000	1.0000			



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP17	17	
50270	17	
Main Warehouse		
FP19	-1	
50270	-1	
Main Warehouse		
ST	14	
45409	3	
46495	10	
47867	1	

52059

X1 mp 09/10/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:04 PM

Page 9

Work Order ID: 51506

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3564-9RevD

Manufactured

No

200

Each

20.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

-2

51258

-2

Main Warehouse

ST

22

44659

1

45825

1

51258

20

D3564-5RevD

Manufactured

No

200

Each

17.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

34806

2

Main Warehouse

FP19

15

48555

1

51257

14

51925

XL mo 09/10/14

XL mo 09/10/14

August 25, 2009 1:34:04 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:04 PM

Page 10

Work Order ID: 51506

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09

Required Date: 8/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2594-3RevC

Manufactured

No

200

Each

542.0000

16.0000



O-Ring, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

51613

X16 MD 09110/14

ST

542

27168

44

29908

498

D2594-1RevC

Manufactured

No

200

Each

348.0000

16.0000



Plug, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

348

42221

16

42807

92

43884

3

46435

2

47251

235

51751

X16 MD 09110/14

August 25, 2009 1:34:04 PM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

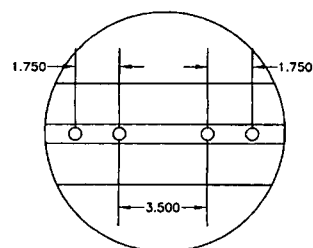
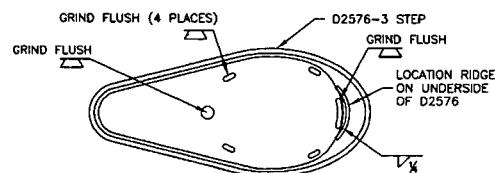
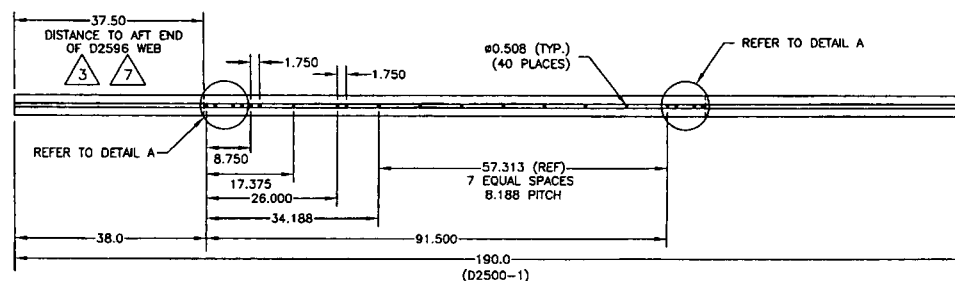
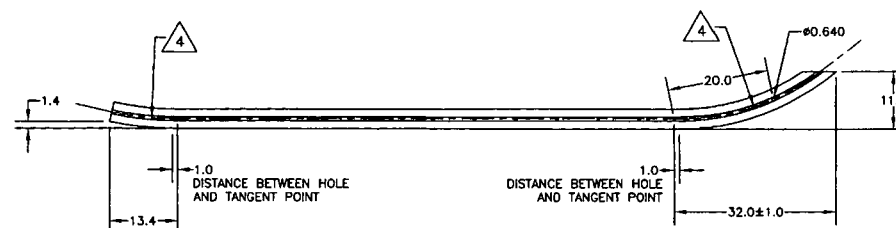
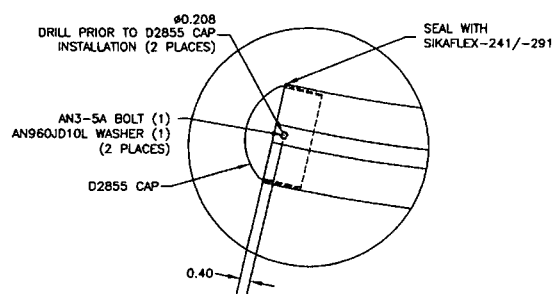
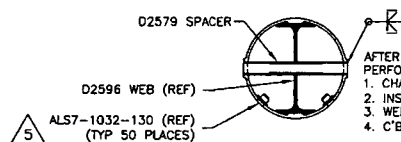
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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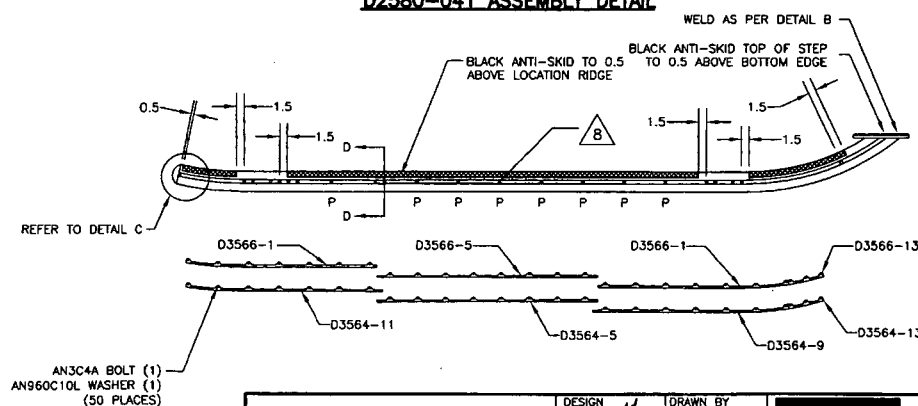
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51506

DETAIL A
SCALE 5:24**DETAIL B**
SCALE 5:24**D2580-1 DRILLING DETAIL****D2580-1 BENDING AND CUTTING DETAIL****DETAIL C**
SCALE 5:24**SECTION D-D**
SCALE 5:24

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

D2580-041 ASSEMBLY DETAIL**D2580-041 NOTES**

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN *[Signature]*DRAWN BY *[Signature]*CHECKED *[Signature]*APPROVED *[Signature]*

DATE

07.02.27

DART**DART AEROSPACE LTD.**
HARRISBURG, ONTARIO, CANADA

DRAWING NO.

D2580

REV. D

SHEET 2 OF 3

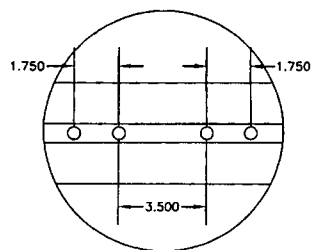
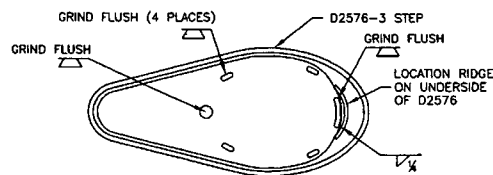
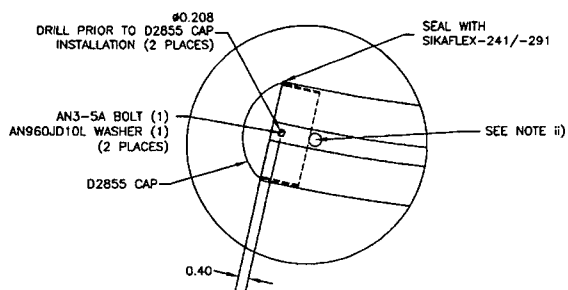
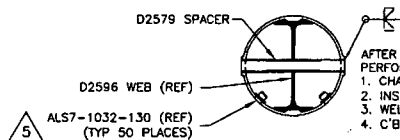
TITLE

205 SKIDTUBE ASSEMBLY

SCALE

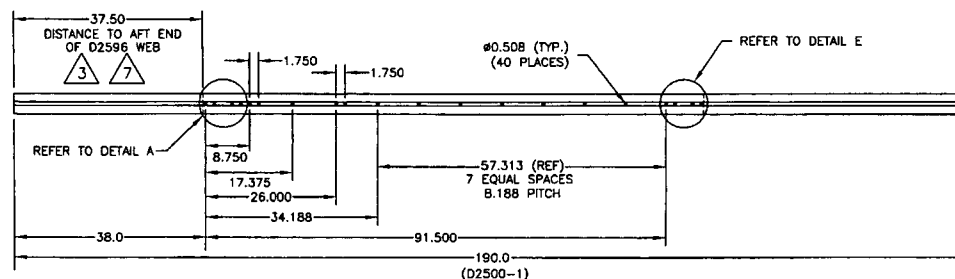
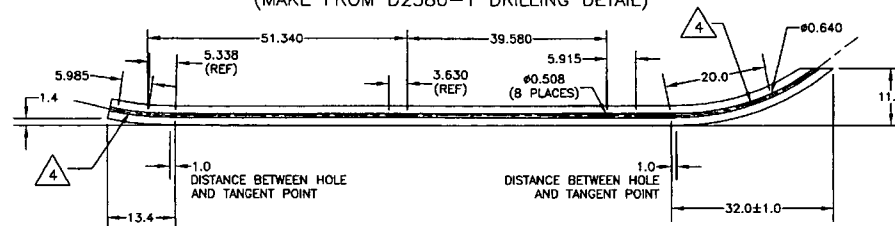
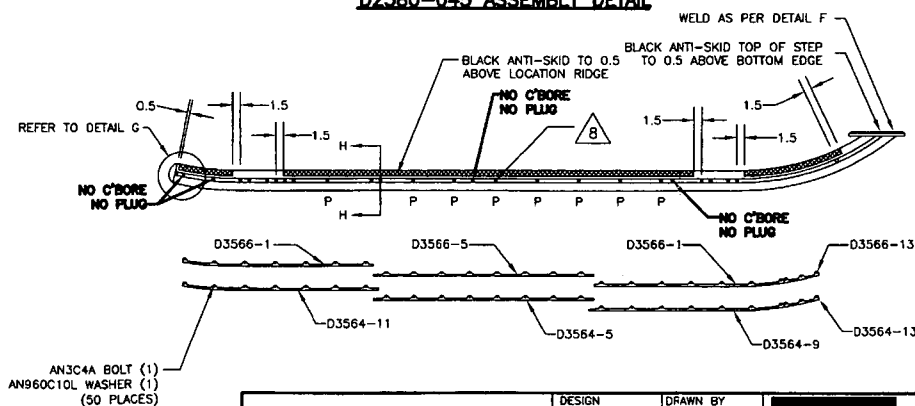
1:24

51506

DETAIL E
SCALE 5:24**DETAIL F**
SCALE 5:24RELEASED
07.06.28**DETAIL G**
SCALE 5:24**SECTION H-H**
SCALE 5:24

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR $\phi 0.508$ HOLES ONLY:

1. CHAMFER HOLE $0.050 \times 45^\circ$
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO $\phi 0.437 \times 1.00$ DEEP

D2580-1 DRILLING DETAIL**D2580-5 BENDING AND CUTTING DETAIL**
(MAKE FROM D2580-1 DRILLING DETAIL)**D2580-045 ASSEMBLY DETAIL****D2580-045 NOTES**

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN RH	DRAWN BY RH	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D2580	REV. 0 SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

NO. 212

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 51505
Part number: D205-634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Dint Date of Test Coupon 09.10.09
Welder Barday Elliott Date of Test Coupon 09-10-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld